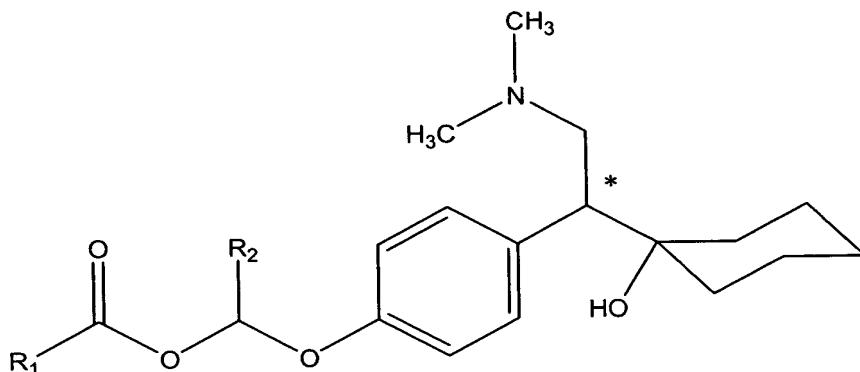


ABSTRACT OF THE DISCLOSURE

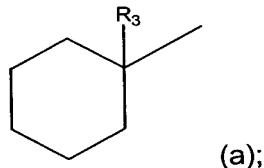
This invention provides O- α -acyloxyalkyl ethers of the venlafaxine metabolite 4-[2-(Dimethylamino-1-(1-hydroxycyclohexyl)ethyl] phenol, represented by Formula 5 (I):



wherein:

the configuration at the steriogenic center (*) may be R, S, or RS (the racemate);

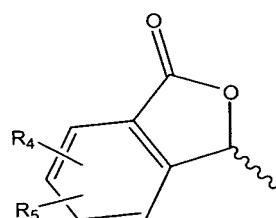
R₁ is selected from C₁ – C₆ alkyl, C₁ – C₆ alkoxy, C₃–C₆ cycloalkyl, or the 10 moiety:



(a);

R₂ is selected from H, or C₁– C₆ alkyl; or,

R₁ and R₂ may be concatenated such that R₁ O – R₂, form a



moiety having formula (b): (b);

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R3 is selected from H or C₁ – C₆ alkyl; and

R4 and R5 are independently selected from H, C₁ – C₆ alkyl, C₃-C₆ cycloalkyl, C₁ – C₆ alkoxy, C₁ – C₆ thioalkoxy, -CN, -OH, -CF₃, -OCF₃, halogen, -NH₂, -NO₂, or mono or dialkylamino wherein each alkyl group has 1 to 6 carbon atoms, or pharmaceutically acceptable salts or hydrates thereof, R, S, or RS forms thereof; as well as pharmaceutical compositions and methods treating central nervous system disorders.